

Date: Wednesday, 6/6/2007 3:45:47 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 32838		Part Number	: D31991	
Estimate Number	: 10283		Drawing Number	: D3199 REV-B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/6/2007	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2007	
Previous Run	: 32471		Qty:	20	Um: Each
Written By					
Checked & Approved By					
Comment	Est Rev:C	Removed Scribing	05-11-05	JLM	
	Est Rev:D	As per Rev B	06-11-24	JLM	

## Additional Product

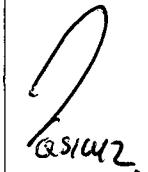
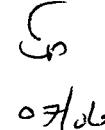
Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304S20GA	304/316 .040 Sheet			
		Comment: Qty.: 0.1040 sf(s)/Unit Total : 2.0790 sf(s) 304/316 .040" SHEET Batch: M104640			SAD 07/06/15 20
2.0	WATER JET	FLOW WATER JET			
		Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: B Prog Rev: B			Deburr SAD 07/06/18 20
		Deburr if required			SAD 07/06/15 20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE			SAD 07/06/15 20
4.0	QC8	SECOND CHECK			
		Comment: SECOND CHECK			SB 07/06/18
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199			SB 07/06/20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/18  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/06/15	2.0	Scrap part Because offset need to be change	 QS1042	Scrap, destroy, replace	SAP 07/06/15	En	 QS1042	 07/06/18	

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart-Helicopters Services

Drawing Name: BRACKET

Job Number: 32838

Part Number: D31991

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Caused

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M 104846

20

Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BL/M/07-06-28

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/06/29 00

20

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/29

Job Completion



07/06/29

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32838
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

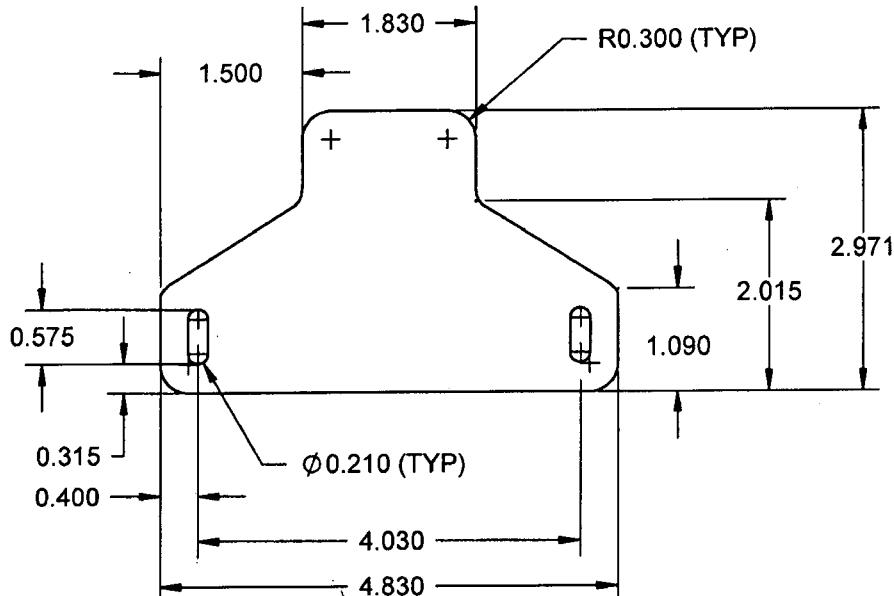
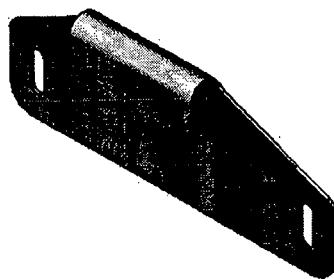
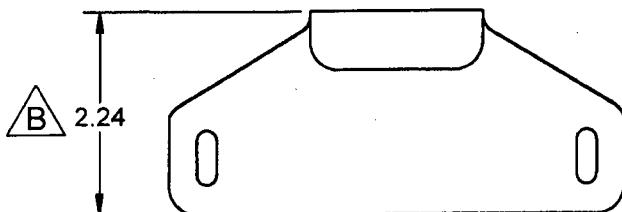
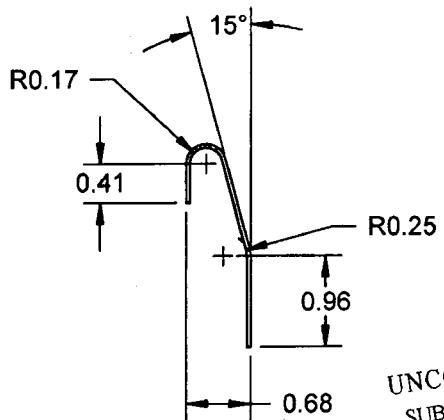
## X First Article Prototype

Measured by:	<u>SAD</u>	Audited by:	<u>Cap</u>	Prototype Approval:	N/A
Date:	<u>07/06/15</u>	Date:	<u>07/06/15</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	Z

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D3199	REV. B	SHEET 1 OF 1
DATE 06.11.01		TITLE BRACKET	SCALE	1:2
REV	DATE	DESCRIPTION		
A	03.08.05	NEW ISSUE		
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG		

**RELEASED***06.11.01 ~~HH~~***D3199-1 FLAT PATTERN****D3199-1 BRACKET**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. *32838*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

